










Date: Monday, 20/04/2009 9:59:15 AM
 User: Julie Dawson


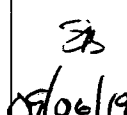



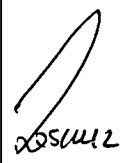
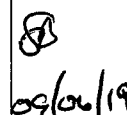

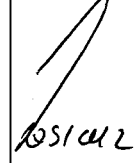
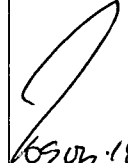
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL LOCK ASS'Y
Job Number	: 47276		
Estimate Number	: 13076		
P.O. Number	:	Part Number	: D3370051
This Issue	: 20/04/2009 S.O. No. :	Drawing Number	: D3370 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 45749	Material	:
Written By	:	Due Date	: 27/04/2009
Checked & Approved By	: <u>JUD 09.04.20</u>	Qty:	2 Um: Each
Comment	: Est. a 07.11.29 new issue EC Est Rev:B 08-07-17 revC as per dwg DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D33701	Pedal Lock Base	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pedal Lock Base BATCH: B45797 (3x) <u>B44287</u> (3x) <u>Ep09/04/23</u>			
2.0	D33703	Pedal Lock Cover	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Pedal Lock Cover BATCH: <u>B45792</u> <u>Ep09/04/23</u> (PK)			
3.0	D33735	Cam Lock	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Cam Lock BATCH: <u>B22383</u> <u>Ep09/04/23</u> ***CHECK WITH PRODUCTION IF KEYED ALIKE OR UNALIKE***			
4.0	D33853	Hinge	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Hinge BATCH: <u>B22387</u> <u>Ep09/04/23</u>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3370-051 PAR #: N/A Fault Category: Machin NCR: Yes No DQA: 11 Date: 09.06.24
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 05/07/15

NCR: <u>47276</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.06.18	2.0	1x D3370-3 is scrap. The screw broke in the hole, and cannot be removed. Threads were not all the way through. RC: Lack of attention @ machining.		Scrap & destroy Qty 1 D3370-3 B45792	 09/06/19	 07/06/22	 05/06/22	 09-06-18
09.06.18	2.0	Qty 5 parts have the hinge & bay hole in the incorrect side & parts do not mate with the -1's. RC: lack of attention/machining		Scrap & destroy. See NCR 09-081	 09/06/19	 09/06/22	 05/06/22	 09.06.18

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 9:59:15 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK ASS'Y

Job Number: 47276

Part Number: D3370051

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	AN526C832R6	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)
Screw
BATCH M16612

EP09/04/23

6.0	D27287	Dart Logo label
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)
Decal
BATCH B22554

EP09/04/23

7.0	HX81	1/4"-20 SHCS 3/8" long
-----	------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
1/4"-20 SHCS 3/8" long
BATCH M110383

EP09/04/23

8.0	AN960416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
Washer
BATCH M19356

EP09/04/23

9.0	D3384041	Cyclic Sock Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
Cyclic Sock Assembly
BATCH 094311

EP09/04/23

10.0	238028	3/16" Dowel Pin .5" long
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)
3/16" Dowel Pin .5" long
BATCH M117278

EP09/04/23

11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3370

EP09/04/23

EP

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 9:59:16 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK ASS'Y

Job Number: 47276

Part Number: D3370051

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



* Locks are stiff but open



Comment: INSPECT WORK TO CURRENT STEP

And close

5/06/19

(42)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



303A

584A



(30)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 492

9/6/22

SP

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-22

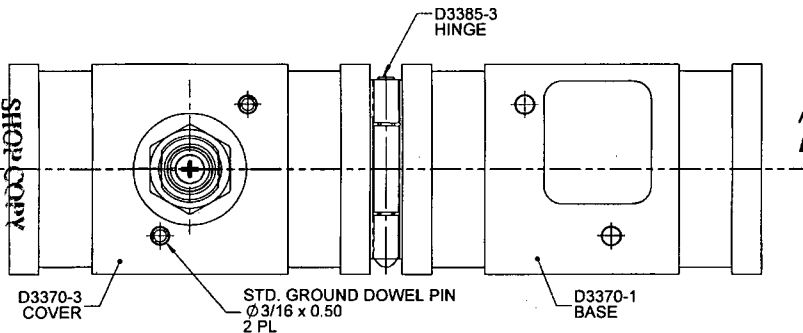
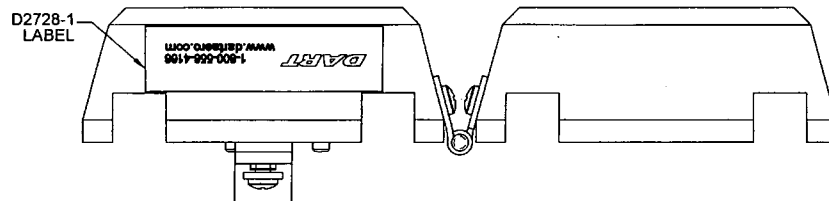
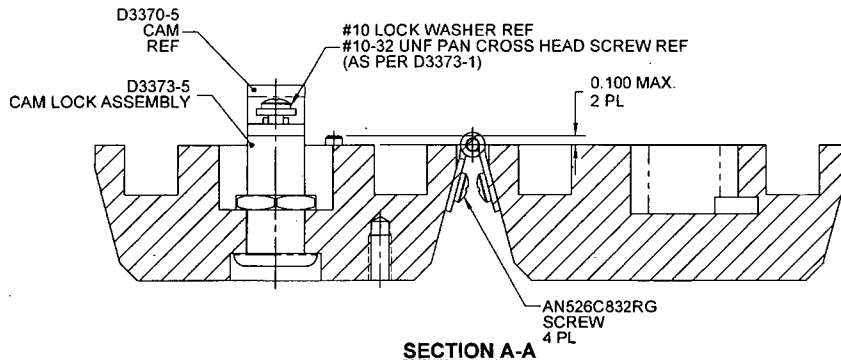
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

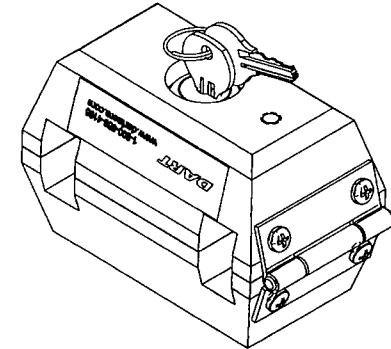
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3370-051 PEDAL LOCK ASSEMBLY



RELEASED
08-07-11

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

NO
B
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	EZ	DRAWING NO. D3370	REV. C
MFG. APPR.		TITLE PEDAL LOCK	SHEET 2 OF 4
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.07.11		

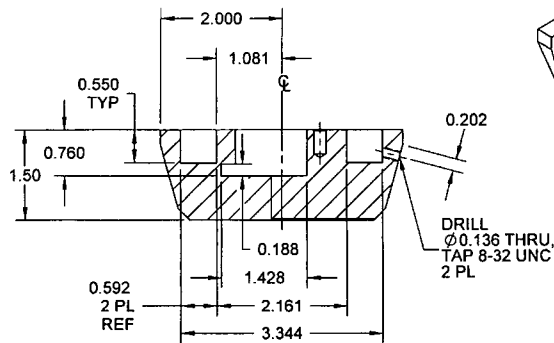
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

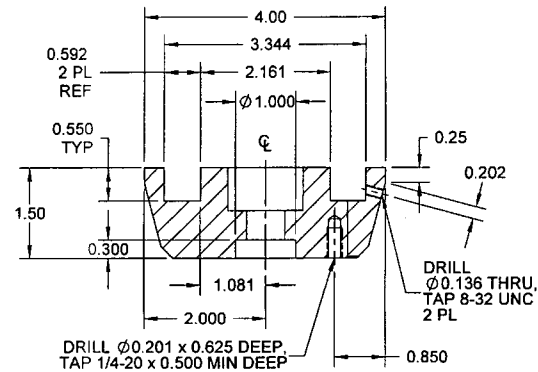
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

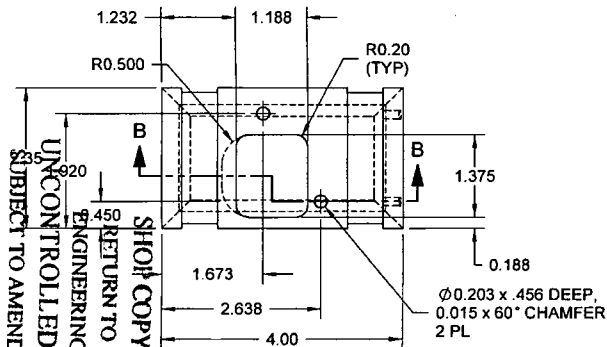
NOTE: Date & initial all entries



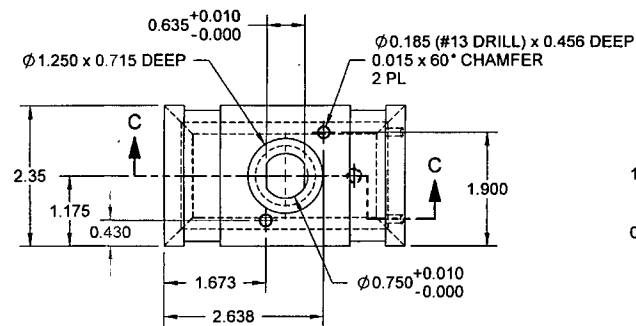
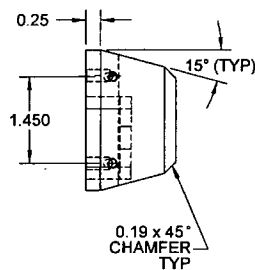
SECTION B-B



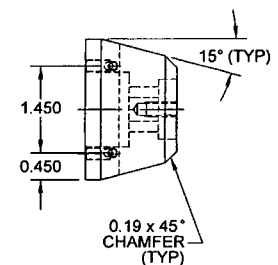
SECTION C-C



D3370-1 BASE



D3370-3 COVER



- NOTES:**
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
REF. DART SPEC. M6061T6B
 - 2) COVER INSIDE HOLES PRIOR PAINTING
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	08.07.11	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08-07-16

WORK ORDER NO. 121210
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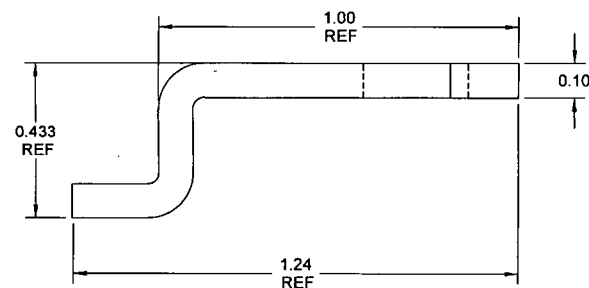
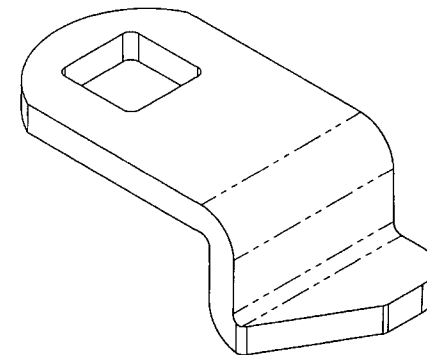
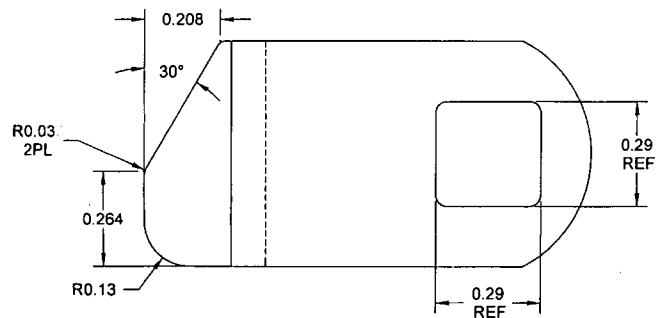
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3370-5 CAM

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 412110

- NOTES:
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
08.07.11

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	FE	DRAWING NO. D3370	REV. C
MFG. APPR.	MP	TITLE PEDAL LOCK	SHEET 4 OF 4
APPROVED	MP	SCALE	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries